

Date: Wednesday, 25/03/2009 12:52:52 PM
 User: Jean-Luc Menard

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : GHW LUG
Job Number : 46697	
Estimate Number : 11217	
P.O. Number :	Part Number : D34041
This Issue : 25/03/2009 S.O. No. :	Drawing Number : D3404 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : C
Previous Run : 45372	Material :
Written By : <i>JLM 09.03.25</i>	Due Date : 01/04/2009 Qty: 30 Um: Each
Checked & Approved By :	
Comment : Est Rev: A 05.09.01 New issue KJ/JLM	
Est rev B 09.01.28 new geometry rev.C EC verified by: DD	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304B0750x2500	304 BAR .750 X 2.50
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Comment: Qty.: 0.2406 f(s)/Unit Total : 7.2167 f(s)
 Material: AISI 304/316 SS Bar 2.50" x 0.75" thick
 (M304B0.750x02.500)
 Identify for D3404-1
 Batch: *M105802*

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2.0	BAND SAW	BAND SAW
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Comment: BAND SAW
 Cut blank: 2.750" long

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3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine as per Folio FA555 and Dwg D3404
 Dwg Rev: *C* Folio Rev: *AA*

2-Deburr

J.F. / DJP 09/03/29

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4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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J.F. / DJP 09/03/29

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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GHW LUG

Job Number: 46697

Part Number: D34041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

88 09/03/31

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

Eric L.

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7.0

QC21

FINAL INSPECTION/W/O RELEASE



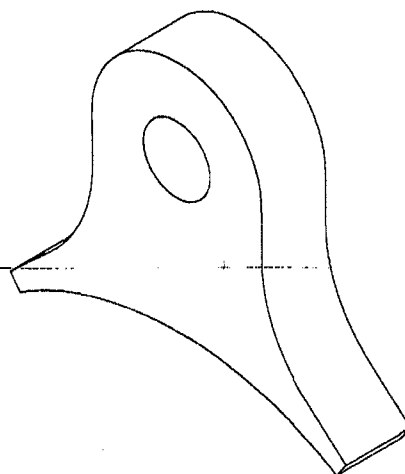
Comment: FINAL INSPECTION/W/O RELEASE

09/04/01

Job Completion



MF 09-03-31



D3404-1 GHW LUG

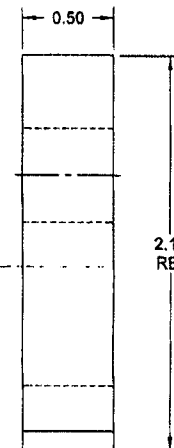
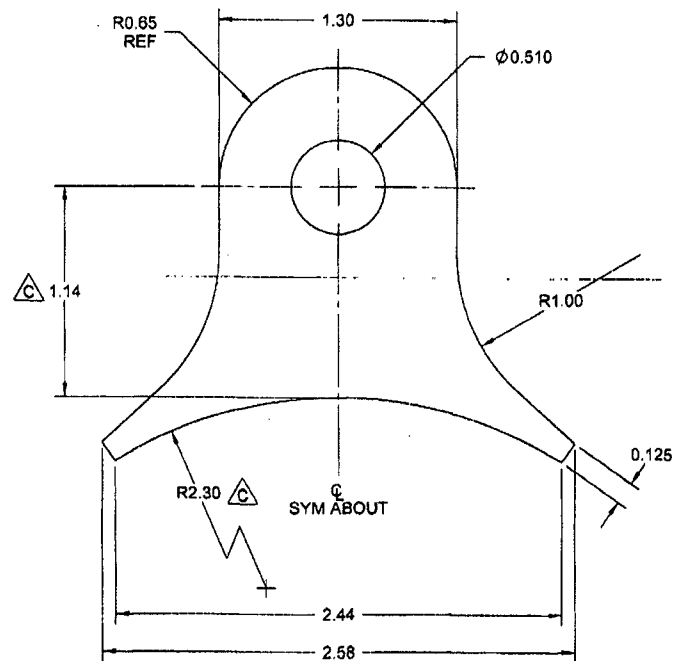
RELEASED
08/12/02

46697

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL BAR
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524
REF. DART SPEC. M304B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.030 TO 0.060 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.34 lbs

C	DRAWING REDRAWN IN SOLIDWORKS WITH CURRENT STANDARDS AND TRANSFERRED TO "B" SIZE BORDER. B6-2, 2.30 RAD WAS 2.13. C7-2 1.14 DIM WAS 1.20.	AJS	08.12.02
B	UPDATE M-SPEC	PH	05.06.14
A	NEW ISSUE	PH	05.03.08
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3404	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		GHW LUG	NTS
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RELEASED
08/12/02

46697

DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3404	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		GHW LUG	NTS
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